

Work Order ID 76048

Thursday, November 03, 2011 12:38:23 PM

76048

Page 1

Item ID: D4095-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 11/4/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/9/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 11-11-03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Set, 063

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Summer

(46)

(C)

B11-11-14

B11-11-14

Work Order ID 76048***76048***

Page 2

Item ID: D4095-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearplate Assembly

Stop ***NS2***

Start Date: 11/4/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/9/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1- bend section C-C first
2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D4095

150

0.00

150Weld per dwg A/R Hardcoat S.S. Batch: M119373

Large Fab

Large Fab

Memo

0.00

Large Fab

X2 JBC 11-11-16

Work Order ID 76048

76048

Page 3

Thursday, November 03, 2011 12:38:23 PM

Item ID: D4095-043 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Assembly

Start Date: 11/4/2011 Start Qty: 6.00 *6*
Required Date: 11/9/2011 Req'd Qty: 6.00 *6*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC10- Inspect visual per QSI004- ground welds 0.00

160

QC Memo 0.00

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC Memo 0.00

180 0.00

180

HandFinish Memo 0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 118602

AS 11/11/16

x2

Work Order ID 76048

Thursday, November 03, 2011 12:38:23 PM

76048

Page 4

Item ID: D4095-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 11/4/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/9/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

2

11-11-17.

200

Identify as per dwg & Stock Location:

0.00

200

Packaging

Memo

0.00

Packaging

2

11-11-17.

210

QC21-Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

11/11/21

11-11-17
2

DART AEROSPACE LTD

Work Order: 76048

Description: WEAR PLATE ASSEMBLY

Part Number: D4095-043

Inspection Dwg: D4095-3 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 19	+ .005 - .001	.191	2		V BOR	
300	± .010	303	2		V	
300	± .010	307	2		V	
2.432	± .010	2.439	2		V	
3.227	± .010	3.222	2		V	
4.06	± .010	4.055	2		V	
2.50	± .010	2.497	2		V	
4.99	± .010	4.982	2		V	
8.43	± .010	8.424	2		Plasma	
11.50	± .010	11.50			T BOR	
21.750	± .010	21.750	2		T	
3.500	± .010	3.500	2		T	
12.22	± .010	12.22	2		T	
6.000	± .010	6.000	2		T	
12.100	± .010	12.100	2		T	
21.00	± .010	21.000	2		T	
30.000	± .010	30.000	2		T	
36.000	± .010	36.000	2		T	
38.89	± .010	38.89	2		T	
.063	± .010	.061	2		V	

Measured by: B

Date: 11-11-04

Audited by: X

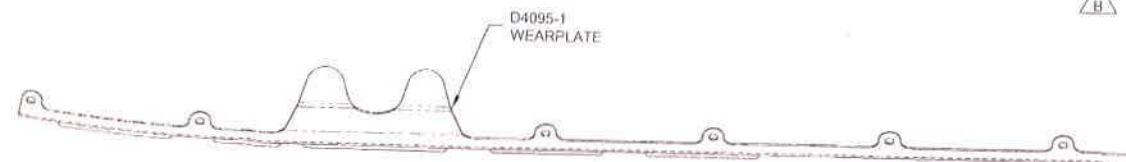
Date: 11/11/07

Prototype Approval:

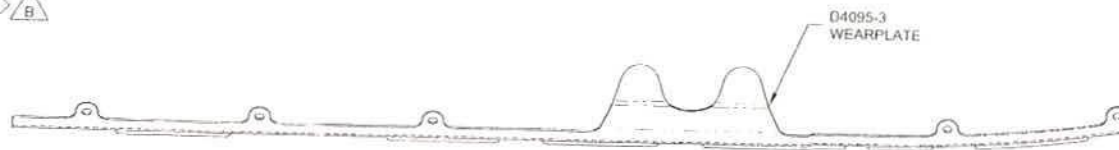
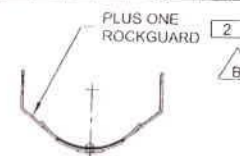
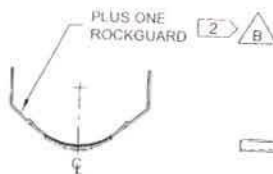
Date:

Rev	Date	Change	Revised by	Approved
A		New issue	KJULM	

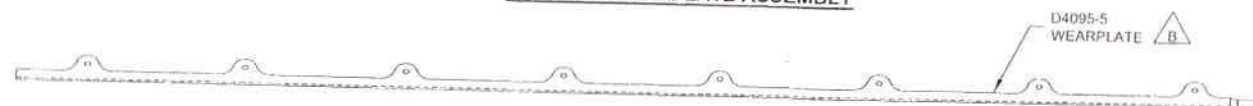
ITEM	QTY 041	QTY 043	QTY 045	QTY 047	QTY 049	QTY 051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



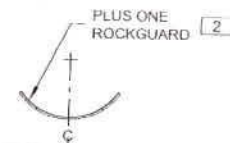
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

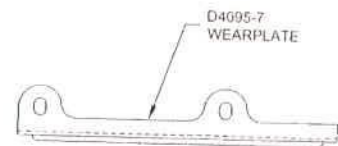
B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

DART AEROSPACE USA, INC
KENT, WA

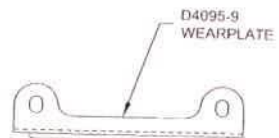
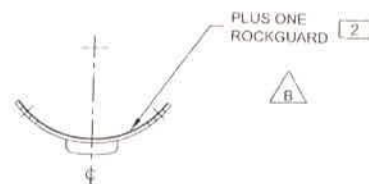
DRAWING NO. D4095
SHEET 1 OF 8

TITLE WEARPLATE
SCALE NTS

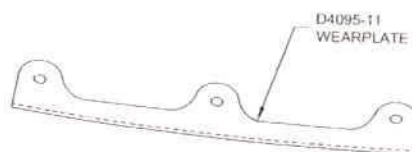
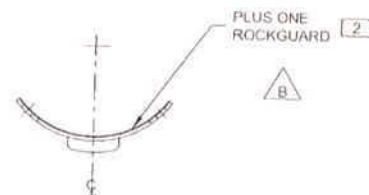
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS UNCLASSIFIED OR CONTROLLED UNDER E.O. 13526
UNCLASSIFIED//FOR OFFICIAL USE ONLY



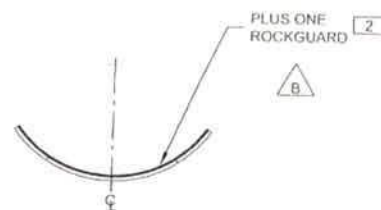
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY

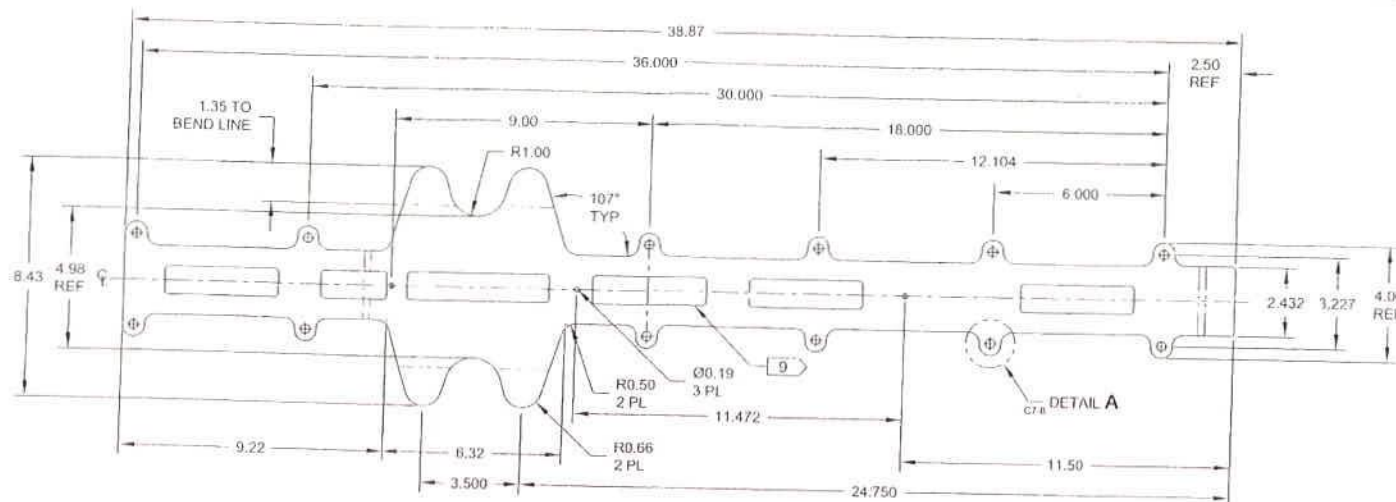


D4095-051 WEARPAD ASSEMBLY

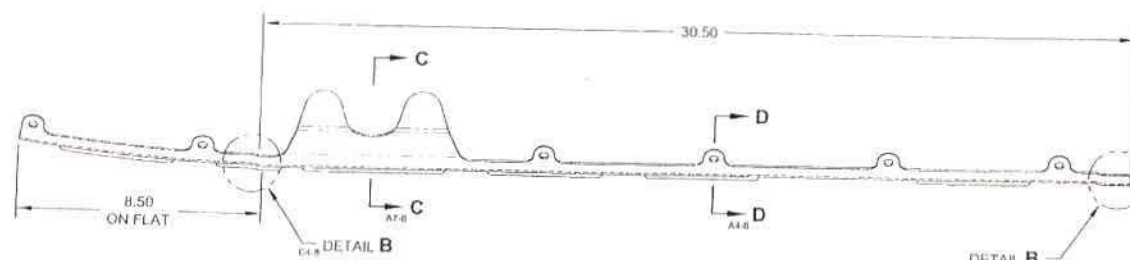


RELEASED
2011-10-3

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 2 OF 8
APPROVED	149	TITLE	SCALE
DE APPR.	149	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS UNCLASSIFIED OR CONTROLLED BY EXPORT ADMINISTRATION. IT IS NOT BE USED FOR ANY PURPOSE OR COUNTRY OR CHARACTERISTICS TO ANY OTHER THAN THE ORIGINAL INTENTED PURPOSE.			



D4095-1F FLAT PATTERN



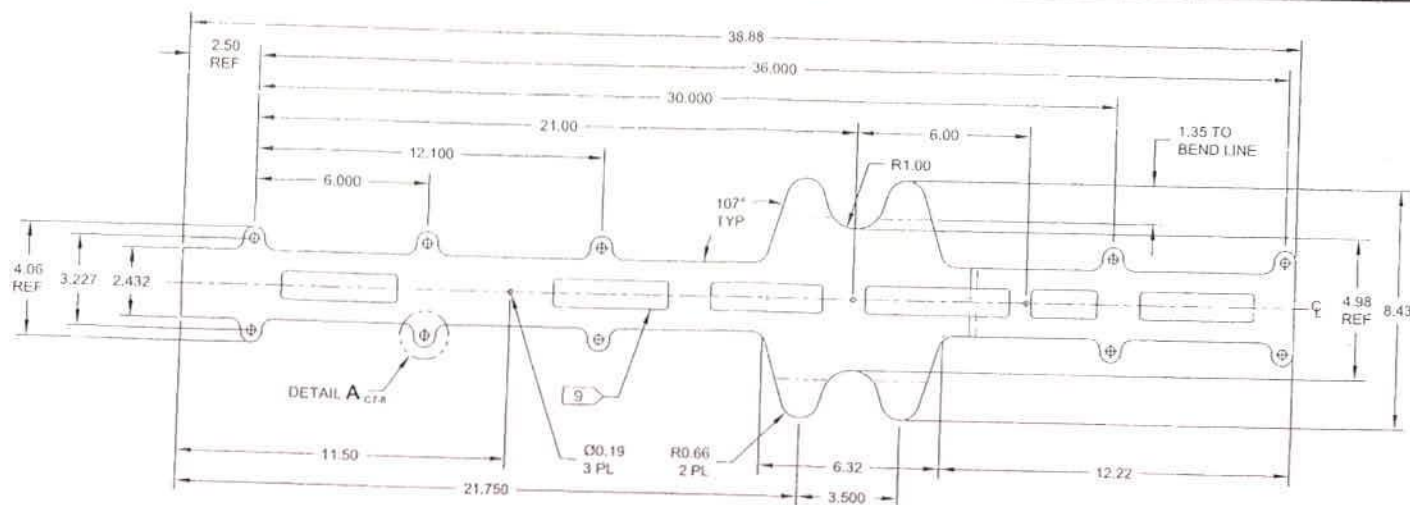
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1F/3F/5F/7F/9F/11F NOTES:

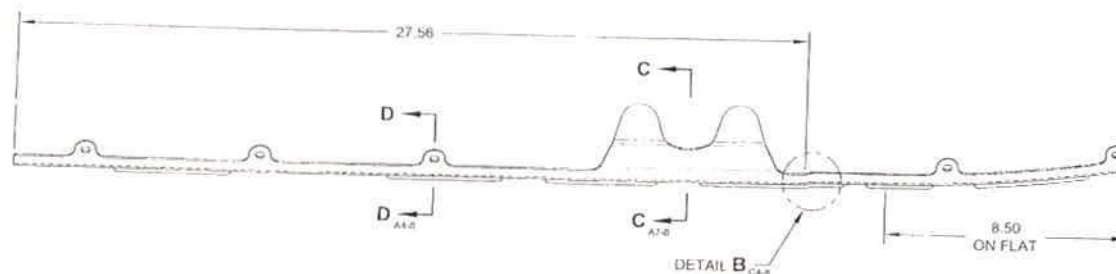
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 3 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS UNLAWFUL TO BE RELEASED TO THE PUBLIC OR THAT IS UNLAWFUL TO BE USED FOR ANY PURPOSE OR TO BE REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC			

76614
RELEASED
2011-10-31
WPD



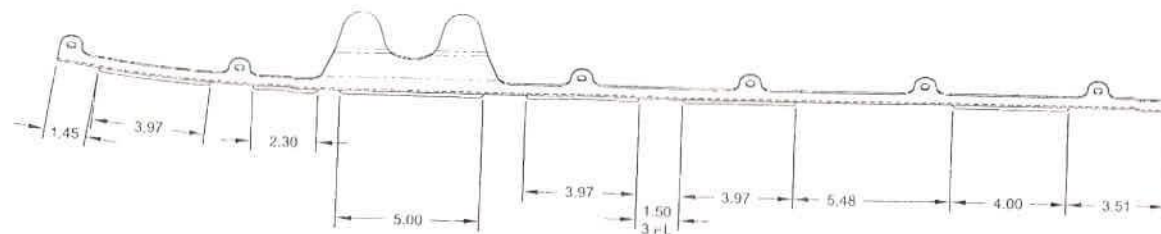
D4095-3F FLAT PATTERN



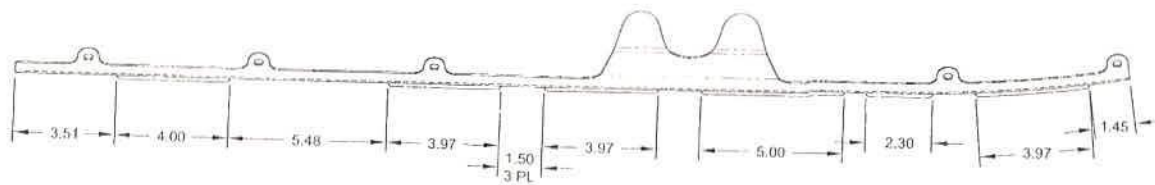
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

RELEASE
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 4 OF 8
APPROVED	149	TITLE	SCALE
DE APPR.	149	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2018 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONTROLLED BY THE EXPORT CONTROL ACT OF 1989 FOR EXPORTATION PURPOSES ONLY. IT IS NOT TO BE USED FOR ANY PURPOSES OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4095-1 WELDING DETAIL

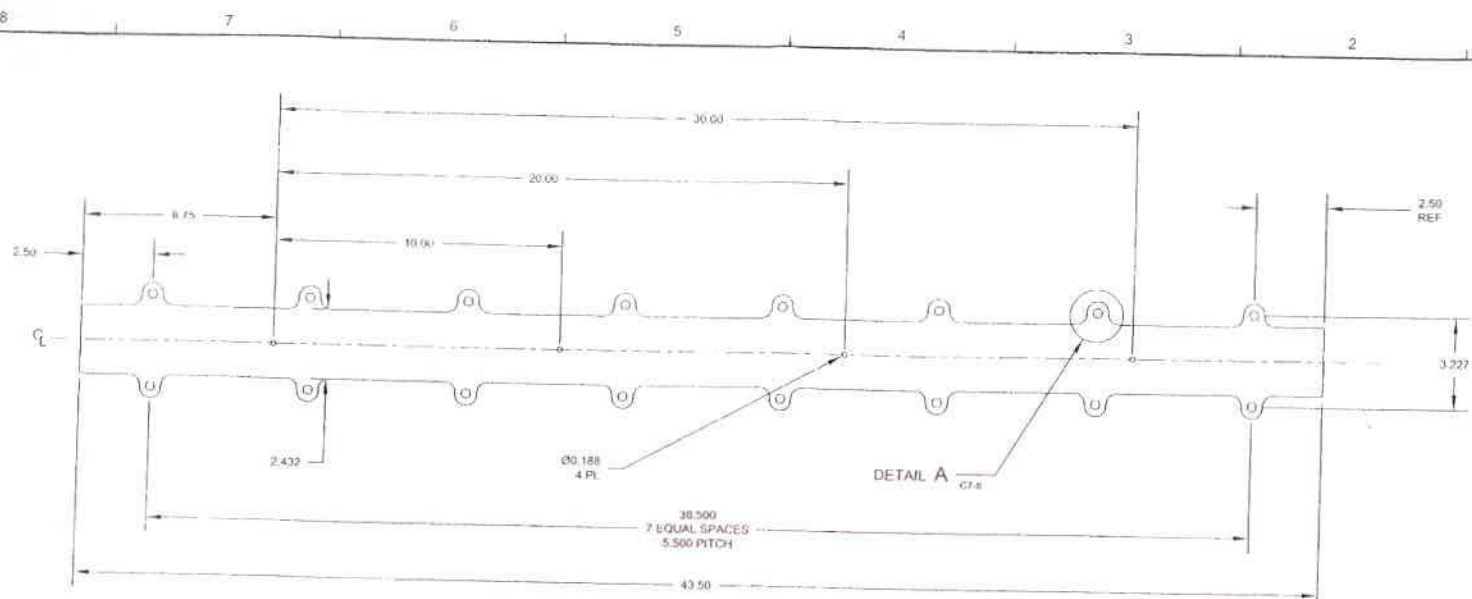


D4095-3 WELDING DETAIL

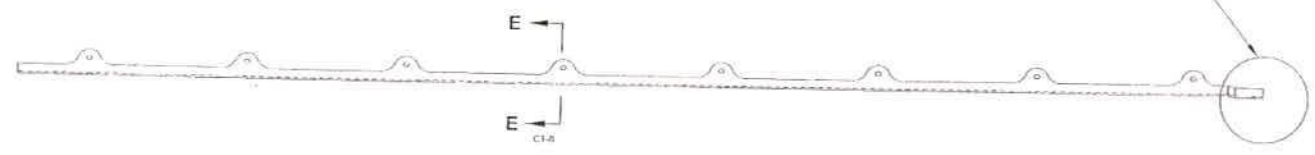


DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>AD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AD</i>	D4095	SHEET 5 OF 8
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. ALL RIGHTS ARE RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.</small>	

REPLACED
 2011-10-3
MD



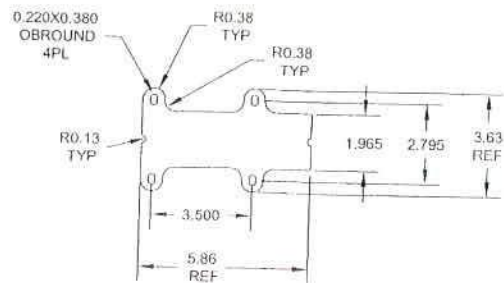
D4095-5F FLAT PATTERN



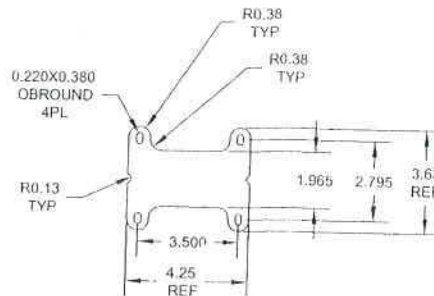
D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

RECEIVED
2011-10-31
MD

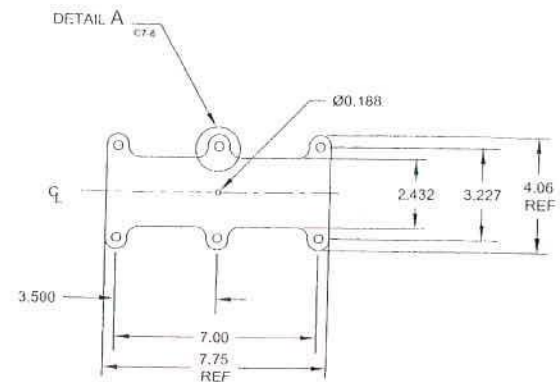
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	110	DRAWING NO.	REV. B
MFG. APPR.	110	D4095	SHEET 6 OF 8
APPROVED	110	TITLE	SCALE
DE APPR.	110	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.</small>	



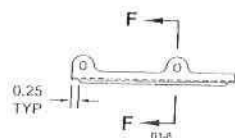
D4095-7F FLAT PATTERN



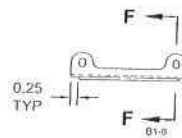
D4095-9F FLAT PATTERN



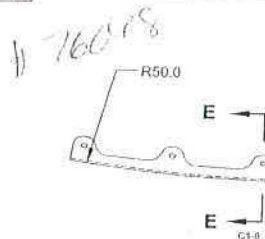
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)

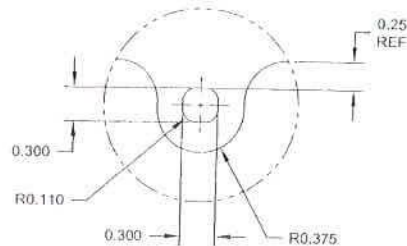


D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



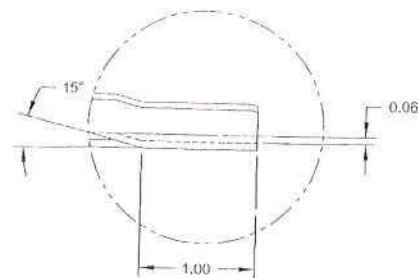
D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 7 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE ORDER AND NOT FOR REPRODUCTION OR FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.			



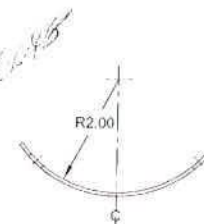
DETAIL A: TAB DETAIL

SCALE 4X
C3-3
C6-4
D2-6
D2-7



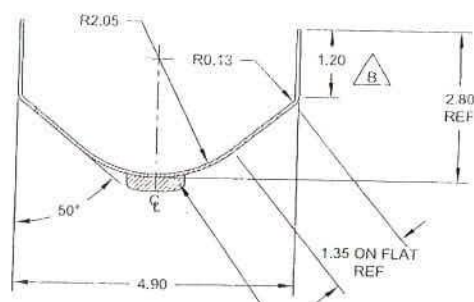
DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-3
B6-3
B3-4
B2-6



SECTION E-E

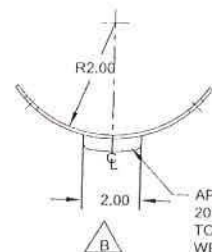
SCALE 2X
B5-6
B2-7



SECTION C-C

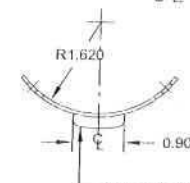
SCALE 2X
B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION D-D

SCALE 2X
B4-3
B5-4



SECTION F-F

SCALE 2X
B5-7
B7-7

RELEASED
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 8 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCTION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.			